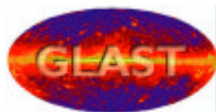


Document Projet / Project Document



GLAST LAT CAL
Mechanical Structure

Ref : GLAST-LLR-PR-068

Issue : B

Date : September 2, 2003

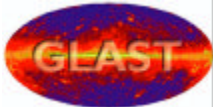
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Procedure of use of preimpregnated

SLAC reference :

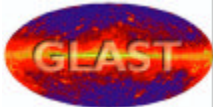
Change History log

B	2 Sept 2003	Taking into account of the comments of the NRL	S. Le Quellec	O. Ferreira	S. Le Quellec	O. Ferreira
A	14 mars 2003	CREATION	S. Le Quellec	O. Ferreira	S. Le Quellec	O. Ferreira
Ind.	Date	Modifications	Prepared	Checked	PA Approval	Project Approval

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1 OBJECT

This document presents the procedure to be followed at the time of the reception, the defrosting and the recondensation of preimpregnated.

2 PARTICULAR PRECAUTIONS

Preimpregnated must be preserved out of freezer with -18°C in a hermetically closed plastic packing.

Its lifespan when it is preserved kind is 1 year.

Its lifespan at ambient temperature is 21 days.

Preimpregnated fears moisture, it must thus be preserved in a hermetic packing.

It should be waited until preimpregnated either at ambient temperature to leave it its packing.

Before opening the bag of preimpregnated, eliminating condensation on the bag with a dry rag. The bag should not be open as long as condensation is formed above.

The handling of preimpregnated when it left its packing, must be carried out in a clean room at controlled temperature and hygroscoy ($20^{\circ}\text{C} \pm 2$; $\text{H} < 60\%$) with not powdered gloves.

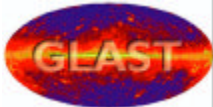
Following card of preimpregnated:

In order to enter the time spent except congelation and to determine the remaining lifespan, a monitoring sheet accompanies preimpregnated at the time of each operation. It must be updated at each stage.

- Operation of the monitoring sheet:
 - o Exit of preimpregnated freezer: the operator informs the date and the hour about the monitoring sheet
 - o Entry of preimpregnated in the freezer: the operator informs the date and the hour, it then calculates the time spent except congelation and withdraws it from the lifespan of preimpregnated.

3 RECEPTION OF PREIMPREGNATED

- ⇒ To carry out the control of entry: to see GLAST-LLR-Pr-071 "Check procedure of entry"
 - o Documentary checking: checking of the documents provided by the subcontractor (card of followed) and of the original documents of Hexcel (analysis, compliance certificate...)
 - o Visual checking (good apparent state of packing)
- ⇒ To publish and/or inform a monitoring sheet, to stick it on packing
- ⇒ If it is about a roller, to obviously identify the date of manufacture of preimpregnated on packing (= date of manufacture) and the n° of the roller
- ⇒ To place preimpregnated in the freezer (-18°C) at less than one immediate use of the product
- ⇒ To announce to the persons in charge Project and Quality the least anomaly

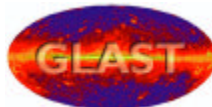
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4 EXIT OF PREIMPREGNATED FREEZER

- ⇒ To always leave preimpregnated the oldest (date of the oldest manufacture)
- ⇒ To check that the expiry date of preimpregnated is not exceeded
- ⇒ To leave preimpregnated packed the oldest by taking care not to pose it on a sharp surface or which could deteriorate preimpregnated or packing
- ⇒ To inform the card of followed which is stuck on packing (Description of the operation to be realized, exit date, time...)
- ⇒ To let defrost preimpregnated in its hermetic packing until complete defrosting. (cf § 3 "particular precautions")
- ⇒ To open packing in a clean room at controlled temperature and hygroscoy (20°C ±2°C; H<60%), to pay attention not to be damaged preimpregnated at the time of the opening
- ⇒ Never not to put the rollers resting against preimpregnated
- ⇒ To handle and store preimpregnated so that it does not become deformed
- ⇒ To announce to the persons in charge Project and Quality the least anomaly

5 ENTRY OF PREIMPREGNATED IN THE FREEZER

- ⇒ To carry out a double hermetic packing (by putting less possible air)
- ⇒ To check the tightness of packing
- ⇒ To identify packing so necessary by indicating the date of manufacture the nature of preimpregnated and its reference
- ⇒ To supplement the monitoring sheet (Date and hour of entry to the freezer)
- ⇒ To calculate the time spent except congelation and the remaining lifespan, to note the results on the monitoring sheet
- ⇒ To reposition the monitoring sheet on packing
- ⇒ To enter preimpregnated the freezer by positioning it in order not to deform it
- ⇒ To position if possible preimpregnated the oldest on the top
- ⇒ To announce to the persons in charge Project and Quality the least anomaly

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 Centre National de la Recherche Scientifique  									
	Fiche suiveuse du pré-imprégné							Réf : GLAST-LLR-FS-OXX Page 1/1	
Informations sur le pré imprégné		Référence : T300 1K PW (TR)M76 N° lot : <u> </u>				Rouleau : n° Date de fabrication : Longueur initiale (m) :			
		Durée de vie en congélateur (-18°C) : 1 an				Durée de vie hors congélation: 21 Jours (A)			
OPERATIONS				Opérateur	Date/Heure Sortie congélateur	Date/Heure Entrée Congélateur	Temps hors congélation (B)	Durée de vie Restante =(A) – (B)	Longueur retirée (m)
Date	Description	T (°C)	H (%)						
Durée totale		<u>TEMPS HORS CONGELATION</u> <u>FREEZER TIME</u>							
Visa Projet - Nom, date et signature :					Visa Qualité - Nom, date et signature :				